

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58830

Wednesday, May 19, 2010 1:07:04 PM



Page 2

Item ID: D3639-4

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 5/19/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

0.00

Brake NC

Memo

Form as per Dwg D3639

SB 10/06/03

(9)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

S 10/06/03

(x2)

=4

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

x9 10/06/07 BB

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Required Date: 5/26/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00				9	0		
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

(X9) BB 10/06/08

10/06/09 JJ

10-6-08
(9)

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Picklist Print

Wednesday, May 19, 2010 1:07:08 PM

Page 1

Work Order ID: 58830



Parent Item: D3639-4



Parent Item Name: Doubler

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	33.9947	0.4277	3.8		



2024-T3 .050 sheet



B 10-6-2

Location

Loc Qty

Loc Code

MAT22

33.9947

111381

30.9

112291

2.7

113189

0.3947

111381

9

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58830
Description: Doubler		Part Number:	D3639-4
Inspection Dwg: D3639 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.625	✓			
Ø0.191	+0.005/-0.001	.192	✓			
Ø0.098	+0.004/-0.001	.1101	✓			
0.45	+/-0.030	.453	✓			
1.350	+/-0.010	1.356	✓			
2.25	+/-0.030	2.252	✓			
3.15	+/-0.030	3.152	✓			
4.05	+/-0.030	4.052	✓			
4.95	+/-0.030	4.950	✓			
5.85	+/-0.030	5.851	✓			
6.75	+/-0.030	6.752	✓			
7.65	+/-0.030	7.653	✓			
8.55	+/-0.030	8.551	✓			
9.350	+/-0.010	9.353	✓			
9.45	+/-0.030	9.452	✓			
10.350	+/-0.010	10.353	✓			
11.25	+/-0.030	11.251	✓			
12.15	+/-0.030	12.15	✓			
12.85	+/-0.030	BEND				
13.86	+/-0.030	13.86	✓			
13.96	+/-0.030	13.96	✓			
0.805	+/-0.010	.805	✓			
1.00	+/-0.030	1.003	✓			
2.100	+/-0.010	2.099	✓			
3.30	+/-0.030	3.301	✓			
2.000	+/-0.010	1.999	✓			
2.590	+/-0.010	2.589	✓			

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-6-2	Date:	10/6/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	AS

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NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

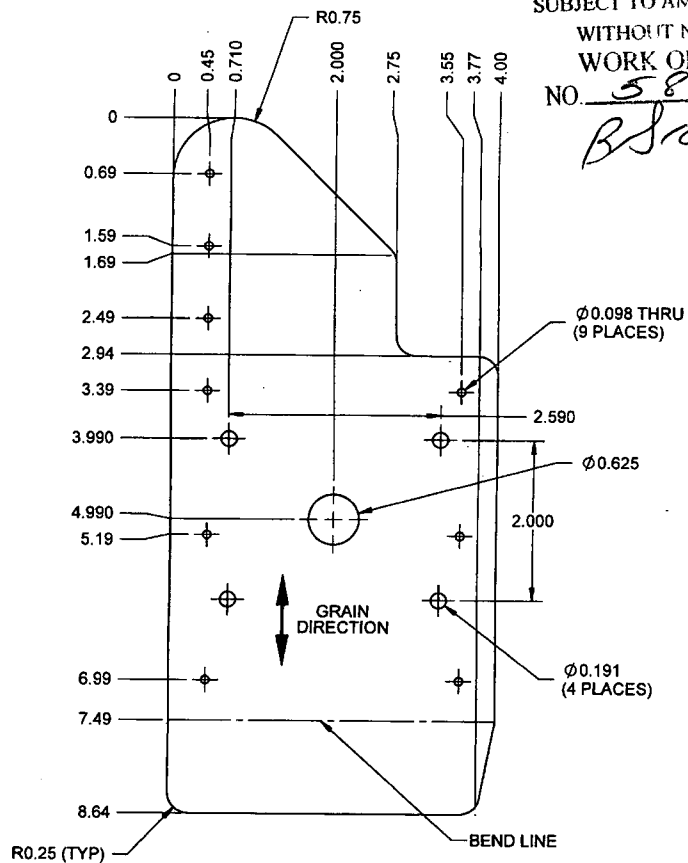
SUBJECT TO AMENDMENT

WITHOUT NOTICE

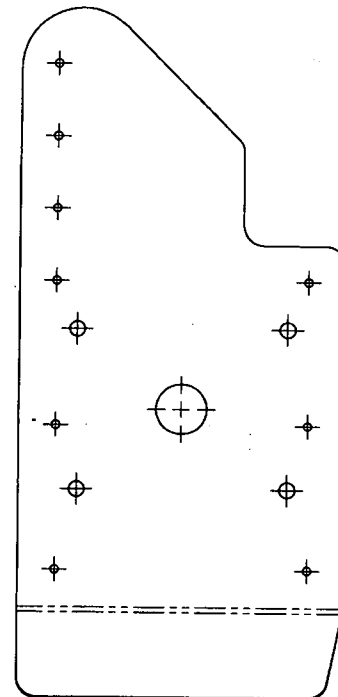
WORK ORDER

NO. 58830

BS10-5-19



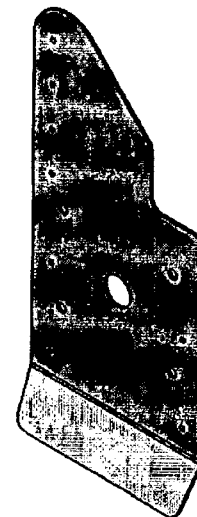
D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)



D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)

8.59

19°
(REF)



RELEASED
07.07.27

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

A	NEW ISSUE; REPLACES G10604		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	LE			
CHECKED	LE	DRAWING NO.	REV. A	
MFG. APPR.	LE	D3639	SHEET 1 OF 2	
APPROVED	LE	TITLE	SCALE	
DE APPR.	LE	DOUBLER	2:3	
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

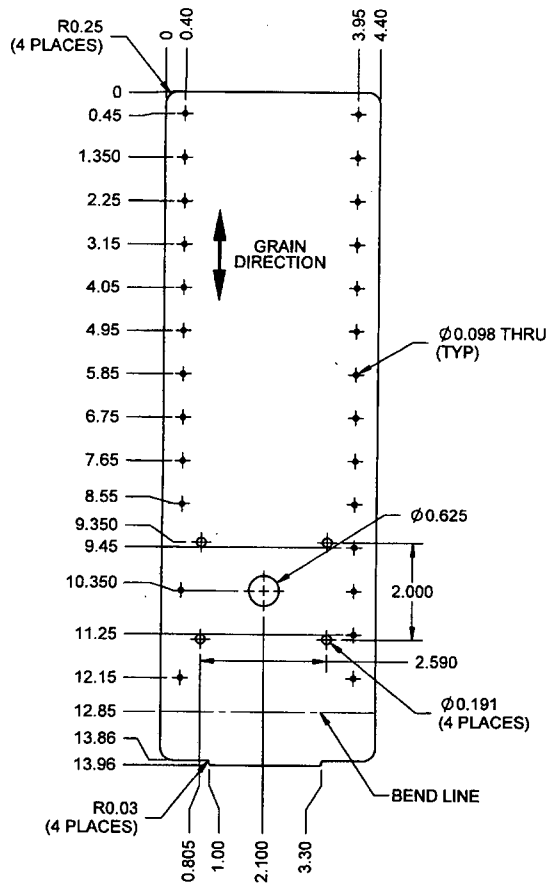
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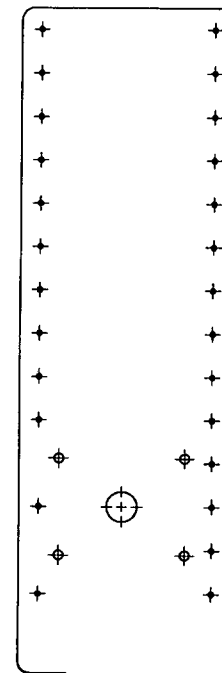
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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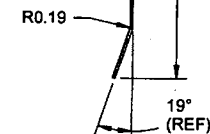
NOTE: Date & initial all entries



**D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)**



**D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)**



RELEASED
07.09.07 #

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.3 lbs

w/o 58830

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	10	D3639	SHEET 2 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	10	DOUBLER	2:5
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